

**ENGINEERING CHANGE NOTICE**  
**DART AEROSPACE LTD**

Date: 19.09.12	Job No.: OV19-13	ADR Yes/No: Y	ADR Date: 19.09.04	ECN #: 19- 883
Product No.: D206-667		Created By: <i>mp</i>	Approved By: <i>mp</i>	
Product Name: Crosstubes		Checked By: <i>mp</i>		

**Reason for Change:**  
NCR on D206-667-203 S198486

**Documents Released:**  
Release DSI 9346 Rev. S

IF APPLICABLE:    NCR: \_\_\_\_\_    PAR: \_\_\_\_\_    CAR: \_\_\_\_\_    CIR: \_\_\_\_\_    URF: \_\_\_\_\_

PAPERWORK UPDATE ☐    PARTS MUST COMPLY ☐    PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Leonardo	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	Y	CP	MDL-D206-667 Rev. T updated by <i>mp</i> for CP. 19.09.13	
7	Update Document Record (DR)	N			
8	Update Product Compatability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	N			
12	Update Product Specification Files (Bluefiles)	Y	N		
13	Update Approved/Preliminary Dwg PDF Files	Y	N		
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	N			
17	Update / Verify Authorized Release Certificate Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	Y	N		
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	N		
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

**Description / Action:**

-DSI 9346 Rev. S released to allow shipment of D206-667-203 S198486, which was deviated during production.

-Add DSI 9346 Rev. S to product specifications as "on request only"

-CP added DSI 9346 Rev. S to D206-667-203 S198486 paperwork

*N/A*      *DR*  
*9-13-2019*

ECN Verified & Complete: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART AEROSPACE LTD**

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Product No.: D206-667		Created By: <i>UP</i>	Approved By: <i>UP</i>	
Product Name: Crosstubes		Checked By: <i>haz</i>		

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NCR on D206-667-203 S198486

**Documents Released:**  
Release DSI 9346 Rev. S

IF APPLICABLE:    NCR: \_\_\_\_\_    PAR: \_\_\_\_\_    CAR: \_\_\_\_\_    CIR: \_\_\_\_\_    URF: \_\_\_\_\_

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*added to box*  
*19-09-13*  
*W*

ECN Verified & Complete: \_\_\_\_\_ Date: \_\_\_\_\_

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

270 Packaging 3-1 - Stock - B4B	1 pcs	8/16/19	0.00 0.00	QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				AUG 26 2019	
275 DC - 1 - B4B	1 pcs	8/16/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
280 QC 21 - FG	1 pcs	8/16/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	
				AUG 26 2019	

need DSI 9346  
rev. S  
received and issued  
see attached.



DAS  
55  
9-89

DAS  
58  
9-89

M/D

Part Op 110 - (CNC Alpha 160 Bender), Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF  
 Descriptions: 120 - (QC15- Crosstube Dimensional Check)

130 - \*\*\*\*\* ENSURE PROPER JIG POSITIONING BEFORE DRILLING\*\*\*\*\* , VERIFIED BY: \_\_\_\_\_ \*\*\*\*\* 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-243. Note: FWD side has 3X top holes facing inboard. 3- C'sink holes as per dwg D206-667-243. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes. Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 5-Drill aft rivet holes using drill Jig DT8787 aft as per Dwg D206-667-243. Drill only the top (2) holes. 6- C'sink holes as per dwg D206-667-243. Allow rivet to sit below surface to compensate for paint. 7- Scribe tube to identify on the inner chamfer in the cuff D# and B# 8-\*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\*Debur & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

135 - (Crosstubes Chemical Conversion), \*\*\*IMMEDIATELY AFTER GRINDING\*\*\*

140 - (QC5- Inspect part completeness to step on W/O), \*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\*

142 - (QC7-Inspect Chemical Conversion Coat)

DAS  
77  
9-89

F9103  
DAS  
77  
9-89

need DSI 9346  
rev. S



received and issued  
see attached.

M/D

DAS  
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DAS  
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M/D.  
Smt